Work Order I Monday, June 27, 20										Page 1
Item ID: D35 Revision ID:	536-11		Accept				s s	etup Sta	rt	
Item Name: Gask	7/2011 Start Qty: 12.00			Cust Item I	D:			Sto		
	ocess Plan:	Date: ~ 06-2	_		nte:		ŀ	tun Sta Sto		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr		· · · · · · · · · · · · · · · · · · ·	~						
D3536	Rev A						·			
Waterjet FLOW CNC Waterjet		per Dwg D3536 □Dwg Rev necessary	0.00	4 □2-			Bu	6-29	(3)	
QC Quality Control	QC2- Inspect parts of	f machine FAI/FAIB	0.00				tB11	-6 <u>-79</u>		-
120 	QC8- Inspect parts - s Memo	second check	0.00 S Wol	e/2 %			(413			

Quality Control

Dart Aeros	pace Ltd
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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	PAR #: Fault Category:			No DQ	A :	Date:		
Resolution:		esolution:	Disposition	_ QA: N/C (Closed:		Date: _			
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)	٠,			
DATE	STEP	Description of NC	Initial	Corrective Action Secondary Action Description	ion B Sign	2. Verific		Approval	Approval	
		Section A	Chief Eng	Chief Eng	Date		on C	Chief Eng	QC Inspector	
		71.					<u> </u>			
							**			
ì	1				I	1		ŀ	1	

Work Order ID 71283

Monday, June 27, 2011 10:46:03 AM



Page 2

Item ID:

D3536-11

Accept

Setup Start



Revision ID:

Start Date:

Item Name: Gasket

Required Date: 7/1/2011

QC:

6/27/2011 **Start Qty: 12.00**

Operation

Description

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date:

SPC (Y/N):

Set Up/

Tooling:

Date: Date: Run

Start

Stop



Stop



Sequence ID/ Work Center ID

130

Packaging Packaging

Memo

Identify as per dwg & Stock Location:

Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CZ 1107/04

Dart Aer	ospace l	Ltd
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	· oopuoo									•	
W/O:			W	ORK ORDER CHANG	iES						
DATE	STEP	PRO	OCEDURE CHA	ANGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								:			
										·	
Part No: PAR #:			Fault Category: NC			NCR: Yes No DQA: Date:					
Resolution:			Disposition: QA:								
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCR)					
DATE	STEP	Description of NC	cription of NC Corrective Actio		veri			rification Approval		Approval	
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti	on C	Chief Eng	QC Inspector	

Picklist Print

Monday, June 27, 2011 10:45:57 AM

Work Order ID: 71283

Parent Item: D3536-11

Parent Item Name: Gasket



Start Date: 6/27/2011

Required Date: 7/1/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	466.6800	0.6728	8.970667	9.		
										PB (-(-39		

NEOPRENE SHEET 0.063

Location	Loc Qty	Loc Code		
MAT052	466.68			
117295	66.68			2
118026	400		118026	(3)
				<u> </u>

Dart Aerospa	ace Ltd
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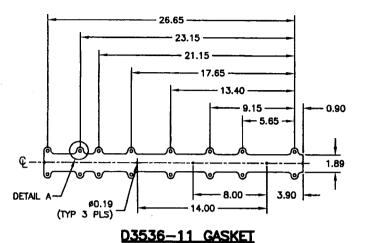
Dai t Aci	Ospace	Llu							• •
W/O:			WO	RK ORDER CHANGE	ES				······································
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No.		DAD #-	Fault Catoo	OTV:	NCP: Vos	No DO	۸.	Date	
Part No: PAR #:									
Resolution:							Date: _ 		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
		Description of NC			Section B Ve		cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector
								·	

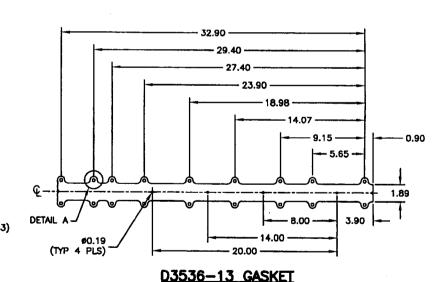


CHECKED APPROVED DRAWING NO. REV.	CB	CB	PORT HADLOCK, WA	» ODA, INC.
D3536 SHEET 1 0 TITLE S 10.25 GASKET 06.10.25 NEW ISSUE	?	APPROVED /	DRAWING NO.	REV. A
10.25 GASKET 06.10.25 NEW ISSUE	#	#	D3536	SHEET 1 OF 6
GASKET 06.10.25 NEW ISSUE	DATE		1MTE	SCALE
A 06.10.25 NEW ISSUE	06.10.25		GASKET	1:10
	Α	06.10.25	NEW ISSUE	







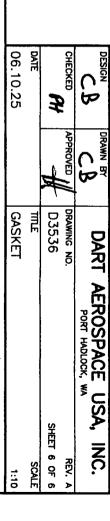


- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
 IDENTIFY WITH DART P/N USING A WHITE FINE POINT
 PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

Dart	Aeros	pace	Ltd

									- 4	
W/O:			W	ORK ORDER CHANG	ES		-			
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Category:N							
Resolution:			Disposition: Q/							
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)		·		
DATE	STEP	Description of NC			ion B	Verifi	cation	Approval	Approval	
DAIL		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector	
				4.v						
			-							
1	1 1							Ī		











2.00 ---

4.00

3.43

DETAIL A

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

27.98 25.08

#0.19 (TYP 2 PLS)

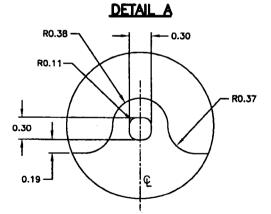
D3536-41 GASKET

1.88

3.90

18.50

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER



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Dart Ae	rospace	Ltd								•
W/O:			W	ORK ORDER CHANGE	ES					
DATE	STEP	PROCEDURE CHANGE			В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	·	PAR #:	Fault Cate	gory:	NCR: \	es N	lo DQA:		Date:	T. 1200 - 10
	Re	solution:	Dispositio	n:	QA: N/	C Clo	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	ICR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	S	gn & Date	Verificat Section		Approval Chief Eng	Approval QC Inspector

DART AEROSPACE LTD	Work Order:	71283
Description: Gasket	Part Number:	D3536-11
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

|--|

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.65	+/-0.030	76.64	24		T 1BOI	
23.15	+/-0.030	23.15	2		7	
21.15	+/-0.030	41.15	2		7	
17.65	+/-0.030	17.64	>		7	
13.40	+/-0.030	13,40	2		7	
9.15	+/-0.030	9.15	7		7	
5.65	+/-0.030	5.65	A		7	·
3.90	+/-0.030	3,90	7		7	
8.00	+/-0.030	8.00	Ø		7	
14.00	+/-0.030	14.00	7		7	
1.89	+/-0.030	1.888	*		V 1802	
0.30	+/-0.030	,310	٢		V	
0.30	+/-0.030	,309	D		V	
Ø0.19	+0.005/-0.001	۱۱۹	7		ν	

Measured by: B		Audited by:	Prototype Approval:	N/A.
Date:	11-6-89	Date: 1 (06/78	Date:	N/A
	, , , , , , , , , , , , , , , , , , , ,	, ,		·

Rev	Date	Change	Revised by Approved
Α	09.05.07	New Issue	KJ/EC 😽

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·			
		·							
		<u> </u>						1,4	
Part No:	<u> </u>	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA:	·	Date:	
	Re	esolution:	Dispositi	on:	QA: N/C Clo	es No DQA: Date: C Closed: Date:			
NCR:		V	VORK ORI	DER NON-CONFORMAN	ICE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign & Date	Verifica Section		Approval Chief Eng	Approval QC Inspector
- -									